

WHAT IS CLAIMED IS:

1. A double-wound center-feed roll comprising at least two webs having regularly spaced lines of weakness, the lines of weakness of the first web being offset from the lines of weakness of the second web, wherein a first portion of the first and second webs at the center of the roll is bonded to form a bond between the first and second webs, and further wherein a second portion of the first and second webs remains unbonded.
2. The double-wound center-feed roll of claim 1 wherein the length of the first portion is about 1.5 meters.
3. The double-wound center-feed roll of claim 1 wherein the length of the first portion is from about 1 meter to about 2 meters.
4. The double-wound center-feed roll of claim 1 wherein the lines of weakness are defined by perforations.
5. The double-wound center-feed roll of claim 4 wherein the perforation width is greater than about 1 mm.
6. The double-wound center-feed roll of claim 1 wherein the length of the first portion is less than about 1% of the entire length of the webs.
7. The double-wound center-feed roll of claim 1 wherein the attachment strength between the webs in the first portion is less than about 20% of the tensile strength of the webs.
8. The double-wound center-feed roll of claim 1 wherein the attachment strength between the webs in the first portion is greater than about 200 grams.

9. The double-wound center-feed roll of claim 1 wherein each web has less than about 15 perforations per 10 cm width of the roll.

10. The double-wound center-feed roll of claim 1 wherein the offset ratio of the perforations of the first web to those of the second web is less than about 70/30.

11. The double-wound center-feed roll of claim 1 wherein the offset ratio is about 50/50, such that each sheet is presented in an amount equal to that of the previous and the subsequent sheets.

12. The double-wound center-feed roll of claim 1 wherein the web is formed from paper, nonwoven or film.

13. The double-wound center-feed roll of claim 1 wherein the strength of the lines of weakness is less than about 20% of the tensile strength of the webs.

14. The double-wound center-feed roll of claim 1 wherein the bond comprises a crimped bond.

15. The double-wound center-feed roll of claim 1 wherein the second portion of the two webs extends to the outside surface of the roll.

16. A method of making a double-wound center-feed roll comprising the steps of:

- a) providing at least a first web and a second web;
- b) perforating the first and second webs to form first and second webs having regularly spaced lines of weakness;

c) offsetting the lines of weakness to form first and second webs having regularly spaced offset lines of weakness;

d) simultaneously winding the first and second webs having regularly spaced offset lines of weakness to form a roll;

e) activating a bonder at the start of the formation of the roll wherein a first portion of the first and second webs is bonded to form a bond between the first and second webs at the center of the roll; and

f) deactivating the bonder prior to completion of the roll wherein a second portion of the first and second webs remains unbonded.

17. The method of claim 16 wherein the bonder comprises a crimping wheel, and further wherein the crimping wheel remains in contact with the webs during the entire winding of the roll.

18. The method of claim 17 wherein the crimping wheel rotates during the entire winding of the roll.

19. The method of claim 16 wherein the strength of the lines of weakness is less than about 20% of the tensile strength of the webs.

20. The method of claim 16 wherein the second portion of the two webs extends to the outside surface of the roll.